

Green

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 3:19:09 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE AND LOCK- DOWN ASSY
 Job Number : 47048
 Estimate Number : 13527
 P.O. Number : Part Number : D3451047
 This Issue : 07/04/2009 S.O. No. : Drawing Number : D3451 REVA
 Prsht Rev. : NC Project Number : N/A
 First Issue : 07/04/2009 Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 45310 Material :
 Written By : Due Date : 14/04/2009 Qty: 1 Um: Each
 Checked & Approved By : mf 09-04-08
 Comment : Est Rev:A 08-06-27 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34517	Tube Handle Arm
✓		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Tube Handle Arm batch: <u>341462 = 2X</u> <u>SP 09.04.16</u>		
2.0	PB6743001103	Tube Handle
✓		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Tube Handle batch: <u>B470860 = 1X</u> <u>SP 09.04.16</u>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1- weld as per dwg PB67-43001 <u>SP 09.04.16 (1X)</u>		
4.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION <u>PD 0904-16 (1)</u>		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>SP 0904/16 (X)</u>		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>SP 09-04-17 (X)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:19:09 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE AND LOCK- DOWN ASSY

Job Number: 47048

Part Number: D3451047

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M18144



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

8:30 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00 AM

JLP 09-04-17

(X1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/17

(2)

9.0

GP211

Rubber Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rubber Handle

batch: M109006✓

CPC09.04.20

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble rubber handle as per dwg PB67-43001

CPC09.04.20

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/04/20

(2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 447

9/4/20

(2)

SB

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

Job Completion



MF 09-04-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

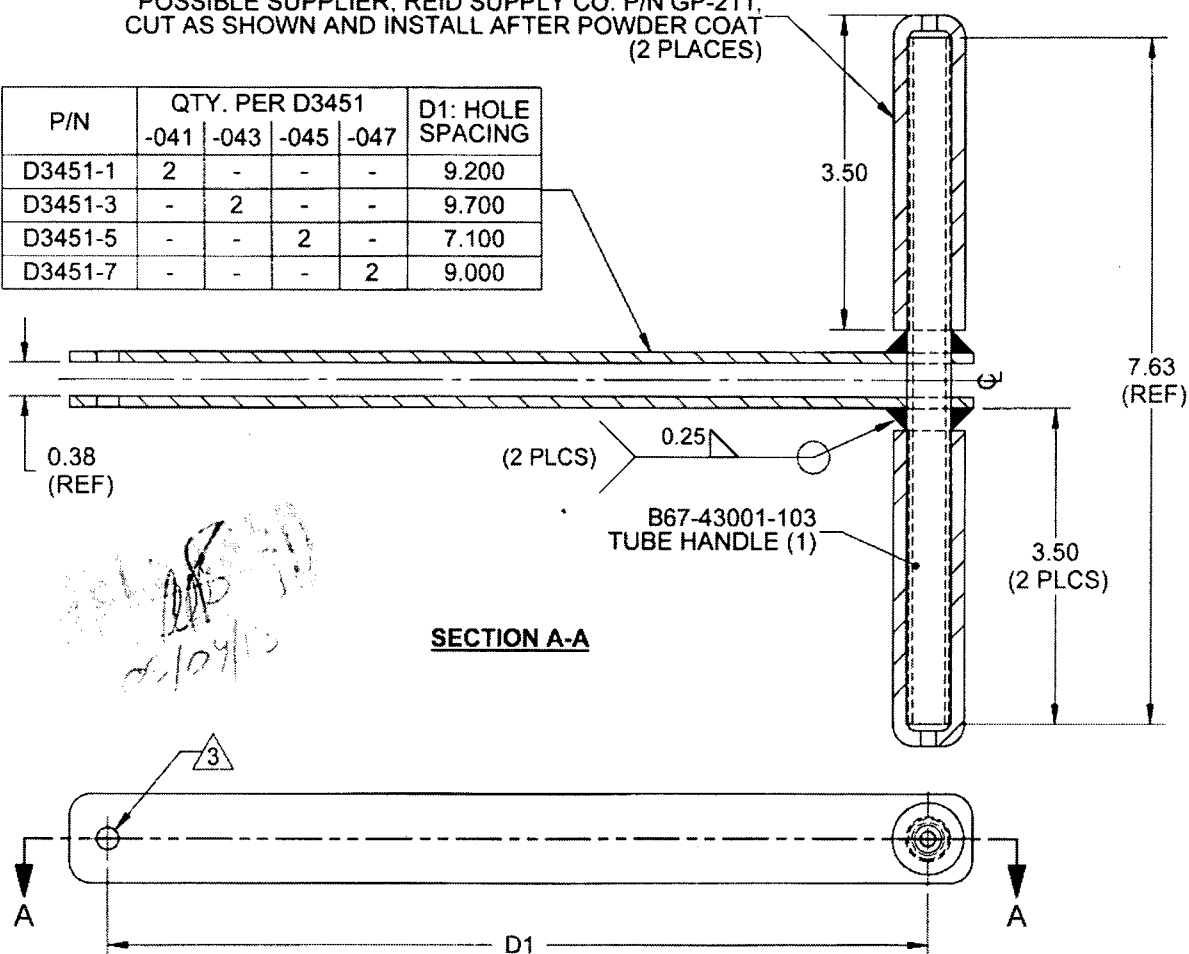
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3451	REV. A SHEET 1 OF 2
DATE 05.08.25	TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2		
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,
CUT AS SHOWN AND INSTALL AFTER POWDER COAT
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41

D3451-045 SUPERSEDES PREMIER P/N B67-43001-39

D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

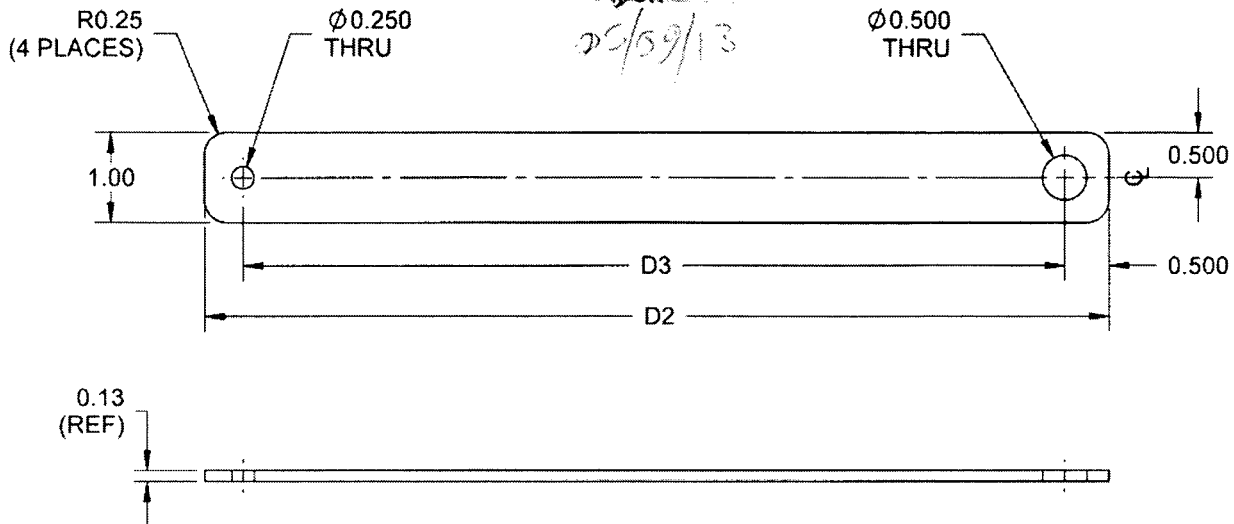
- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451	REV. A SHEET 2 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2	



P/N	D2: CUT LENGTH	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

D3451-1/-3/-5/-7 TUBE HANDLE ARMS**D3451-1 SUPERSEDES PREMIER P/N B67-43001-303****D3451-5 SUPERSEDES PREMIER P/N B67-43001-301****D3451-7 SUPERSEDES PREMIER P/N B67-43001-101****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

477048